

Work Order ID 109554

109554

Page 1

November-21-13 2:34:30 PM

Item ID: D206-648-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Ground Handling Wheel Modification

Start Date: 11/25/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/25/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-11-22

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

| | |
|----------|-------|
| D206-648 | Rev B |
|----------|-------|

100

0.00

100

DC

Document Control

Memo

Photocopy bluefile and create labels per PPP D206-648-013
CHG002

0.00

DAS
6
9-89

13/12/20

(4)

mha

(4)

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

4

DAS
33
9-89

13-12-18

DAS
31
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

DAS
6
9-89

13/12/20

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|-----------------------------------------------------|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

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| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
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Work Order ID 109554

109554

Page 2

November-21-13 2:34:30 PM

Item ID: D206-648-013 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Ground Handling Wheel Modification
 Start Date: 11/25/13 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 11/25/13 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---------------------------------------|----------------------------------------------------------------|------------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 *130* Packaging | Memo Identify and pack for shipping as per PPP D206-648-013 | 0.00 0.00 PK 013 | | | | (4) | 8 | 13-12-20 | |
| 140 *140* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | 13-12-23 | |

MCS 13-12-23
WF 13-12-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
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| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

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Picklist Print

November-21-13 2:34:29 PM

Page 1

Work Order ID: 109554

Parent Item: D206-648-013

Parent Item Name: Ground Handling Wheel Modification

Start Date: 11/25/13

Required Date: 11/25/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A05.09.23New issueKJ/JLM
IPP Rev:B 07-12-05 ECN 1080p DD verified by:

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|-------------------|--------|
| D2652 Bushing | | Manufactured | No | | | 110 | Each | 893.0000 | 8 | 32 | | DAS 33 9-89 | |

Location Loc Qty Loc Code

FG 44

31985 44

ST013 117

101755 5

106590 88

83744 8

89617 16

ST014 732

102204 126

103022 200

103642 200

103643 200

99029 6

102204

DAS
6
9-89

DAS
9-89

D3414-041

Lug

Manufactured No

110 Each 5.0000

2 108853⁸ DAS
33
9-89

13-12-18

Location Loc Qty Loc Code

ST420 1

83859 1

ST445 4

102158 1

106451 3

DAS
6
9-89

DAS
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
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| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
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FAULT CATEGORY

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Picklist Print

November-21-13 2:34:29 PM

Page 2

Work Order ID: 109554

Parent Item: D206-648-013

Parent Item Name: Ground Handling Wheel Modification

Start Date: 11/25/13

Required Date: 11/25/13

Start Qty: 4.00

Required Qty: 4.00

AN3C37A
BOLT

Purchased No

110 Each 99.0000

4

16

DAS
33
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST324

4

M121068

4

ST353

95

122491

1

M126176

4

M126345

90

DAS
31
9-89

NAS1149C0363R
Washer

Purchased No

110 Each 1,457.0000

4

16

DAS
33
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

757

114742

757

ST292

700

114742

33

122063

18

122441

649

DAS
31
9-89

MS210433
Nut

Purchased No

110 Each 1,144.0000

4

16

DAS
33
9-89

13-12-18

Location

Loc Qty

Loc Code

FG

80

103691

80

ST315

1064

124555

176

m126741

888

DAS
31
9-89

DAS
6
9-89

November-21-13 2:34:29 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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FOR INSTALLATION INSTRUCTIONS/REQUIREMENTS AND TECHNICAL INFORMATION SEE APPLICABLE
DART INSTALLATION INSTRUCTIONS.

| QTY -011 | QTY -013 | PART NUMBER | DESCRIPTION |
|-------------|-------------|--------------|---------------------|
| X | | D206-648-011 | GROUND HANDLING KIT |
| | X | D206-648-013 | GROUND HANDLING KIT |
| 8 | 8 | D2652 | BUSHING |
| 2 | | D2659 | GHW LUG |
| | 2 | D3414-041 | LUG ASSEMBLY |
| 4 | | AN3-37A | BOLT |
| | 4 | AN3C37A | BOLT |
| | 4 | AN960C10 | WASHER |
| 4 | | AN960JD10 | WASHER |
| 4 | | MS21042-3 | NUT (OR MS21042L3) |
| | 4 | MS21043-3 | NUT |

RELEASED
09/02/16 MW

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|------------|-------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|
| B | INSTALLATION AND WEIGHT AND BALANCE INFORMATION TRANSFERRED TO DART INSTALLATION INSTRUCTIONS D206-642. ALL HARDWARE UPDATED TO SS HARDWARE. | | AJS | 08.09.24 |
| A | NEW ISSUE | | JB | 97.11.03 |
| REV. | DESCRIPTION | | BY | DATE |
| DESIGN | JB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | AJS | | | |
| CHECKED | | DRAWING NO. | REV. B | |
| MFG. APPR. | N/A | D206-648 | SHEET 1 OF 1 | |
| APPROVED | | TITLE | SCALE | |
| DE APPR. | | GND HANDLING WHEEL (GHW) INSTL | NONE | |
| DATE | 08.09.24 | | <small>COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

FOR INSTALLATION INSTRUCTIONS/REQUIREMENTS AND TECHNICAL INFORMATION SEE APPLICABLE
DART INSTALLATION INSTRUCTIONS.

REFERENCE ONLY

13/12/20

DAS
6
9-89

| QTY -011 | QTY -013 | PART NUMBER | DESCRIPTION |
|-------------|-------------|--------------|---------------------|
| X | | D206-648-011 | GROUND HANDLING KIT |
| | X | D206-648-013 | GROUND HANDLING KIT |
| 8 | 8 | D2652 | BUSHING |
| 2 | | D2659 | GHW LUG |
| | 2 | D3414-041 | LUG ASSEMBLY |
| 4 | | AN3-37A | BOLT |
| | 4 | AN3C37A | BOLT |
| | 4 | AN960C10 | WASHER |
| 4 | | AN960JD10 | WASHER |
| 4 | | MS21042-3 | NUT (OR MS21042L3) |
| | 4 | MS21043-3 | NUT |

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| DRAWN | AJS | | | |
| CHECKED | | DRAWING NO. | REV. B | |
| MFG. APPR. | N/A | D206-648 | SHEET 1 OF 1 | |
| APPROVED | | TITLE | SCALE | |
| DE APPR. | | GND HANDLING WHEEL (GHW) INSTL | NONE | |
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